

Work Order ID 85273

June-05-12 10:53:30 AM

85273

Page 1

Item ID: D3772-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Back Leg

Start Date: 05/06/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 19/06/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/06/05 Tooling:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Date:

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

Draw Nbr

Revision Nbr

D3772

Rev A

100

0.00

100

BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blank 31.500" long

ent 12/06/09

6 x

110

0.00

110

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1- Mill as per Foliō FA787 Rev: AA & Dwg D3772 Rev: A

ET

12-06-10

Y6

120

0.00

120

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

ET

12-06-10

Y6

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 130 | QC8- Inspect parts - second check | 0.00 | | | | | | | |
| *130* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |
| 140 | | 0.00 | | | | | | | |
| *140* | Small Fab | | | | | | | | |
| Small Fab | Memo | 0.00 | | | | | | | |
| Small Fab | 1-cut tube to length as per dwg D37722- deburr3-bend tube as per dwg D3772 | | | | | | | | |
| 150 | QC5- Inspect part completeness to step on W/O | 0.00 | | | | | | | |
| *150* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

am 12/06/11

6

10

FF

12-07-13

*DAS
16
2-03*

12/07/13

(46)

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Work Order ID 85273***85273***

Page 3

June-05-12 10:53:30 AM

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Revision ID:

Stop ***NS2***

Item Name: Back Leg

Start Date: 05/06/2012 Start Qty: 6.00

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Cust Item ID:

Required Date: 19/06/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Identify as per dwg & Stock Location: **81234**, 0.00***160***

Packaging

Memo

0.00

Packaging

6x**SP**
12-7-13

170

QC21- Final Inspection - Work Order Release

0.00

170

QC

Memo

0.00

Quality Control

12/17/17**ME****12-07-16**

| W/O: | | WORK ORDER CHANGES | | | | | |
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NOTE: Date & initial all entries

Picklist Print

June-05-12 10:53:33 AM

Page 1

Work Order ID: 85273

85273

Parent Item: D3772-1

D3772-1

Parent Item Name: Back Leg

Start Date: 05/06/2012

Required Date: 19/06/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A 08-06-18 rev.A as per dwg DD verified by:EC
IPP Rev:B 08-09-24 Now on Haas JLM Verified By:EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| M304TR1.250W.125 | | Purchased | No | | | 110 | f | 54.2500 | 2.6252 | 16.58021 | | | |

M304TR1 250W 125

**

304 RD Tube 1.250 x .125w

Location

Loc Qty

Loc Code

MAT037

54.25

113494

6

114812

4

→ 121317

44.25

16.59 on 12/06/09

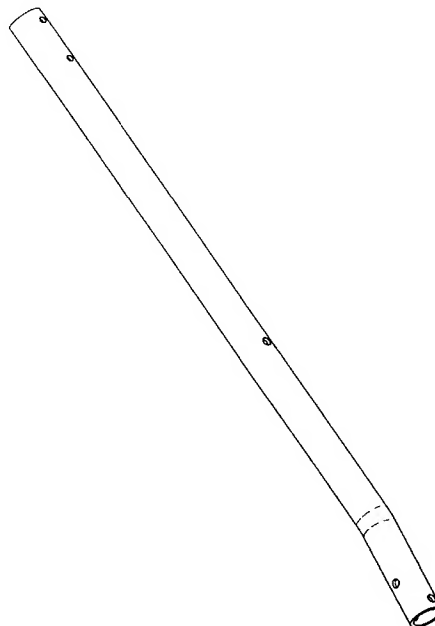
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NOTE: Date & initial all entries



D3772-1 BACK LEG

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER

NO. 85273 MLO
12/06/05

RELEASED
05-05-12-774

NOTES:

- 1) MATERIAL: AISI 304/316 SS TUBING 1.25" OD X 0.125" WALL (REF DART SPEC M304TR1.25W.125)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 3.26 lbs

| A | NEW ISSUE | HS | 08.06.03 |
|------------|--------------------|----|----------|
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | HS | | |
| DRAWN | HS | | |
| CHECKED | <i>[Signature]</i> | | |
| MFG. APPR. | <i>[Signature]</i> | | |
| APPROVED | <i>[Signature]</i> | | |
| DE APPR. | <i>[Signature]</i> | | |
| DATE | 08.06.03 | | |

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3772** REV. A
SHEET 1 OF 2
TITLE **BACK LEG** SCALE NTS

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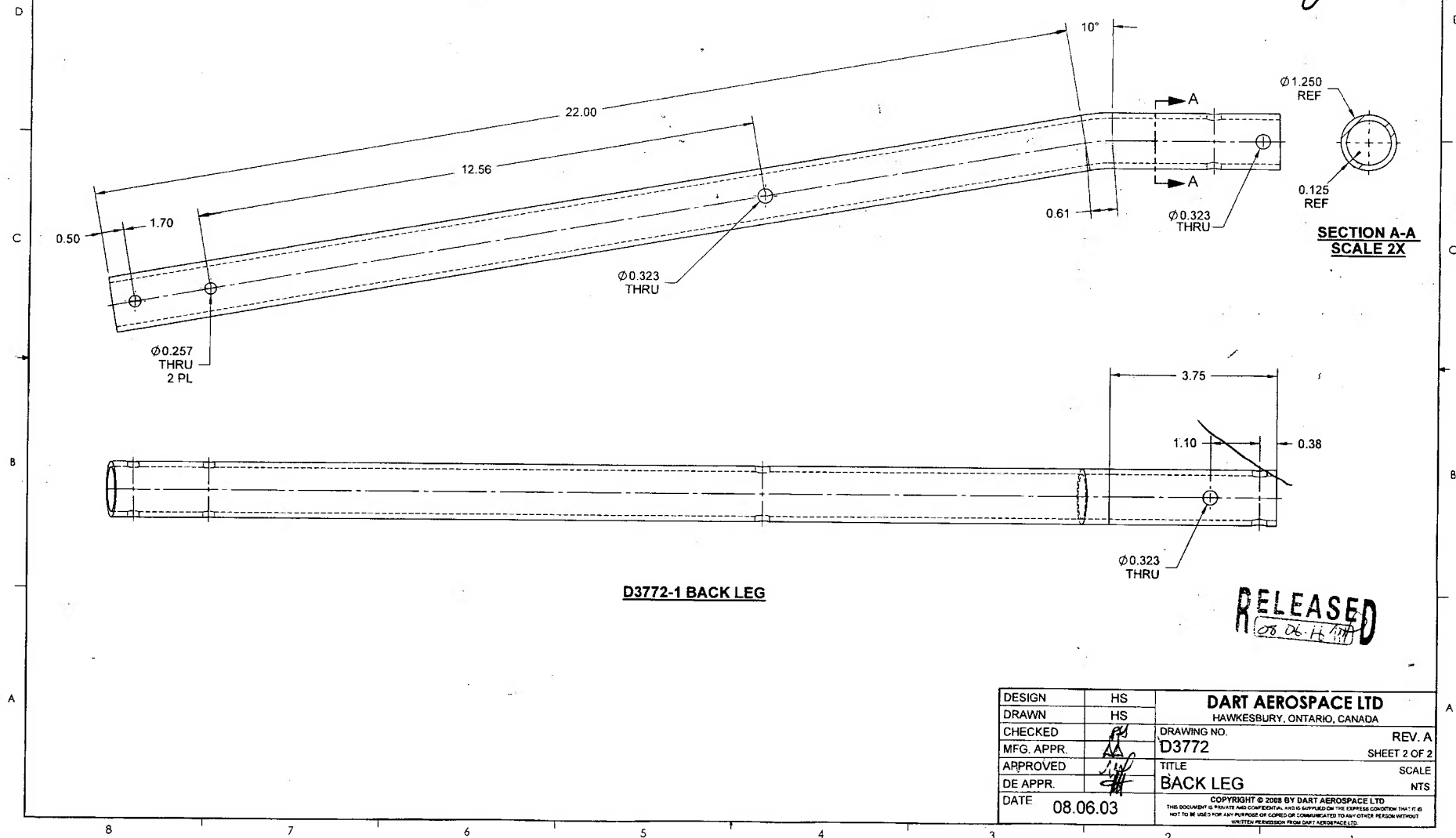
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NOTE: Date & initial all entries

05273



SECTION A-A
SCALE 2X

RELEASED
08.06.03

| | | | |
|--|----------|--|--------------|
| DESIGN | HS | DART AEROSPACE LTD | |
| DRAWN | HS | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | AS | DRAWING NO. | REV. A |
| MFG. APPR. | AS | D3772 | SHEET 2 OF 2 |
| APPROVED | AS | TITLE | SCALE |
| DE APPR. | AS | BACK LEG | NTS |
| DATE | 08.06.03 | COPYRIGHT © 2008 BY DART AEROSPACE LTD | |
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